

Date: Tuesday, 1/3/2006 4:14:58 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE BILLET
Job Number : 25351	
Estimate Number : 10034	
P.O. Number : N/A	Part Number : D6101005
This Issue : 1/3/2006 S.O. No. : N/A	Drawing Number : D6101 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 25350	Material : N/A
Written By : <u>See Comment Below</u>	Due Date : 7/15/2006
Checked & Approved By : _____	Qty: 100 Um: Each
Comment : Est. A: 01.05.04 New Issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: 00000339

AP 06/01/04

a) Description: Alluminum billet

b) 5.00" x 8.250" x 2.50" thick

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Grain direction along 5.00" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

2.0	D6101005	7075-T7351 8.25X5.0X2.5
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)
 7075-T7351 8.25X5.0X2.5

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

L.P. 06/17/14 100

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6101

BC 06.07.17 100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 12 Date: 06/07/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/3/2006 4:14:59 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET

Job Number: 25351

Part Number: D6101005

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *CNC*

RL

06.07.17

NGO

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.17

Job Completion



06.07.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

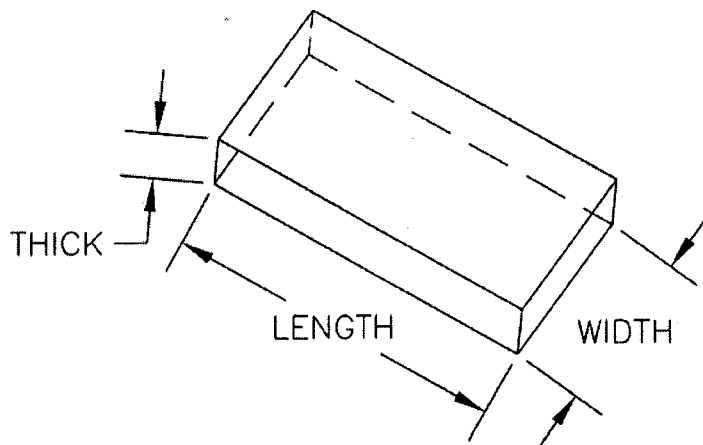
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>JS</i>	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23 *#*



ONCE COPY
RETURN TO
ENGINEERING
CONTROL COPY
SUBJECT
WILL
25351

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

Copyright © 2001 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

31 533688 604947 01

MelauX Castle

A.M. CASTLE & Co. (Canada) Inc. SHIPPED JUL 13 2006

533688

REQUISITION CLIENT-CUSTOMER REQUISITION NO.

NO. COM. CLIENT-CUST. ORD. NO.

COMPT-ACCT.

VEND-SLS

TERR.

EXPEDIE PAR-SHIP VIA

PO 00000339

91037 200 40

CABANO (PPD)

HETEUR-PURCHASING AGENT

TELEPHONE

H/C

TAXE

NO. COM ORD

REGION LIVRAISON-DEL ZONE

F.A.B.-F.O.B.

BILL

NO. FEVILLE/EMBALLAGE-B/L NUMBER

LINDA LACELLE

613 632-3336

9 0

1 C/C

PREPAID

A105024

/RE A-SHIP TO:

VENDU A-SOLD TO:

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY

ON K6A 1K7

INFORMATION CREDIT-CREDIT INFORMATION

R2C SEE FRANCE STATUS

ROUTE

01-NL-04/2

30-NL-05/0

31-NL-07/1

INSTRUCTIONS/LIVRAISON-DELIVERY

INQ-B29602

INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)

SCRIPTION - ITEM 1

2.5000 PLATE 7075-T7351 ALUM 8.25" X 5.00"

BLACK W/RED STRIPE

QTE/UNITE COM. ORDERED

POIDS COM. WT. ORDERED

100 PCS PCS

1042

BALLOTS-BUNDLES

PCES/PC EXP. SHIP

POIDS EXP. WT. SHIPPED

L 100

1042

FORME-SHAPE

I.A.C.

34.360SQF

6879

CERTIFICATE OF CONFORMANCE

INSTRUCTIONS

A.M. Castle & Co. certifies that the material(s) supplied under this document will meet and conform to the specifications of the product(s) described hereon.

A.M. Castle & Co. (Canada) Inc.

THICKNESS TOL.: +.030"/-.000"
ATTN MARTINE: PAS AVANT 13 JUIL
TOL.: +.025"/-.000"
SKID: TYPE 3A
GRAIN TO RUN ALONG 5.00"

COULÉE INFO-HEAT INFO QTE-QTY

347150 AS

INSTRUCTIONS (CONT'D.)

100x8.25"x5.00"

WEIGHT FOR SHIPPING PURPOSES ONLY. SEE INVOICES FOR ACCURATE BILLING WEIGHT. PLEASE SIGN AND DATE DRIVER'S COPY FOR RECEIPT OF MATERIAL AND, IF CHECKED, TEST REPORTS.

SCRIPTION - ITEM 2

TERMS AND CONDITIONS
OF SALESEE DISCLAIMERS AND LIMITATIONS
ON THE REVERSE SIDE

INSTRUCTIONS

1 SKID

COULÉE INFO-HEAT INFO QTE-QTY

INSTRUCTIONS (CONT'D.)

QTE/UNITE COM. ORDERED

POIDS COM. WT. ORDERED

BALLOTS-BUNDLES

PCES/PC EXP. SHIP

POIDS EXP. WT. SHIPPED

FORME-SHAPE

I.A.C.

SCRIPTION - ITEM 3

ALL EXCEPTIONS FOR SHORTAGE OR DAMAGE MUST BE NOTED ON THE DRIVER COPY & CUSTOMER COPY OF THE DELIVERY RECEIPTS & SIGNED BY THE DRIVER & CUSTOMER. COPY OF SUCH RECEIPT PROPERLY NOTED MUST BE SUBMITTED WITHIN 10 DAYS WHEN CREDIT IS REQUESTED.

INSTRUCTIONS

100/2/14

COULÉE INFO-HEAT INFO QTE-QTY

INSTRUCTIONS (CONT'D.)

QTE/UNITE COM. ORDERED

POIDS COM. WT. ORDERED

BALLOTS-BUNDLES

PCES/PC EXP. SHIP

POIDS EXP. WT. SHIPPED

FORME-SHAPE

I.A.C.

NOM (LETRE MOULEE)-NAME (PRINT ONLY)

RECU PAR-RECEIVED BY

DATE RECU-
DATE RECEIVED

FEVILLE D'EMBALLAGE - PACKING SLIP

SHIP TO:
A M CASTLE & CO
3400 NO. WOLF ROAD
FRANKLIN PARK, IL 60131

**KAISER
ALUMINUM**

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4064596

SOLD TO:
AM CASTLE & CO
3400 NO. WOLF ROAD
FRANKLIN PARK, IL 60131

CUSTOMER PO NUMBER: 01-82185		WORK PACKAGE:	CUSTOMER PART NUMBER: 6879		SHIP RUN/LOAD ID: 100651/13	GOV'T CONTRACT NUMBER: A97075-60
KAISER ORDER NO: 1033617	LINE ITEM: 1	SHIP DATE: 17-APR-2006	ALLOY: 7075	CLAD: BARE	TEMPER: T7351	
WEIGHT SHIPPED: 3612 LB	QUANTITY: 2 PCS EST.	B/L NUMBER: 208101	GUAGE: 2.5000 IN	WIDTH: 48.500 IN	LENGTH: 144.500 IN	

Certified Specifications

AMS 4078/RevF
ASTM B 209/Rev04
BSS 7055/RevA
EAC MS1011/RevA
MMS 159/RevN

AMS-QQ-A-250/12
ASTM B 594/Rev02
CSTI 008/RevB
GSS16100/RevG
PS 21211/RevJ

AMS-STD-2154
BAC 8439/RevH
DPS 4.713/RevN/AmdA
MIL-STD-2154

Test Code: 4297

Test Results

Lot: 347150A5 Cast 885 Drop 51 Ingot 2

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	69.1 : 70.1 (476 : 483)	56.1 : 57.8 (387 : 399)	10.5 : 10.8
Conductivity %IACS :			41.4 Min	41.7 Max	
(MS/M) :			24.0 Min	24.2 Max	

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.11	0.25	1.46	0.04	2.49	0.20	5.76	0.03	0.01	0.01	TOT 0.04

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075 MIN	0.00	0.00	1.20	0.00	2.10	0.18	5.10	0.00	0.00	0.00	EACH	0.05
MAX	0.40	0.50	2.00	0.30	2.90	0.28	6.10	0.20	0.08	0.05	TOT	0.15

Aluminum Remainder

CASTLE METALS FP
DATE REC'D 4.20.06 IAC 6879
APPROVED BY: SW

KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4064596

TEST NOTES

Metal represented by this test report was immersion
ultrasonically tested from one side and meets the Class A
and Class B requirements of all specifications referenced
on this test report.

CERTIFICATION

KAISER ALUMINUM & CHEMICAL CORPORATION (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED AND MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER ALUMINUM & CHEMICAL CORPORATION LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULANT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR

